

Work Order ID 132781

May-07-15 2:22:19 PM

132781

Page 1

Item ID: D4778-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Stub Cover
 Start Date: 5/07/15 Start Qty: 10.00 ***10*** Cust Item ID:
 Required Date: 5/07/15 Req'd Qty: 10.00 ***10*** Customer:
 Reference:

Approvals: Process Plan: MCS Date: MAY 08 2015 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D4778	B

100		0.00							DAS 07 9-89
100									
HandThermo	Memo	0.00							
Hand Finishing Thermoforming	1-Cut Sheet to required Blank size								15/05/13

105		0.00							DAS 07 9-89
105									
HandThermo	Dry Material	0.00							
Hand Finishing Thermoforming	Memo								
	Dry Sheet as per QSI022 POLYCARBONATE								

Temp: 245 deg. F
 Time IN: 5:00 PM
 Time OUT: 6:00 AM

MAY 13 2015

Per... Oh

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			
				Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabelled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

May-07-15 2:22:19 PM

Item ID: D4778-1

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Stub Cover

Stop *NS2*

Start Date: 5/07/15 **Start Qty:** 10.00

10

Cust Item ID:

Required Date: 5/07/15 **Req'd Qty:** 10.00

10

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** **Tooling:** **Date:**

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/
Work Center ID

Operation Description

Set Up/ Run Hours

Tool ID	Tool #	Plan Code
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Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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110

0.00

110

0.00

Thermoform

Thermoforming Machine

Memo

1-Machine Set-Up
2-Pre-heat Tool to required temp.
3-Thermoform as per Dwg and Folio #FTA153 using tool DT9887

Dwg Rev: B

Folio Rev: $\mathcal{B}$

Visually inspect for proper formation and texture

140

0.00

140

0.00

HandThermo

Hand Finishing Thermoforming

Memo

1-Trim to finished dimensions as per Dwg

DAS
07
9-89

15/05/14

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
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				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
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Stop *NS2*

Start Date: 5/07/15 **Start Qty:** 10.00

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Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

[illegible]

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Page 4

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Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

QC21- Final Inspection - Work Order Release

0.00

180

QC

Memo

0.00

Quality Control

MAY 19 2015

MAY 19 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order update only ☐

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Picklist Print

May-07-15 2:22:18 PM

Page 1

Work Order ID: 132781

132781

Parent Item: D4778-1

D4778-1

Parent Item Name: Stub Cover

Start Date: 5/07/15

Required Date: 5/07/15

Start Qty: 10.00

Required Qty: 10.00

Comments:

Rev. A New Issue 13/03/12 DL

Rev. B

Relaxed Tolerances on Dwg. 13/05/23 DL

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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MLEXS.093-F6006-02

Purchased

No

100

sf

1,306.500

2

22

DAS

07

9-89

MI FXS 093-F6006-02

GE PLASTICS LEXAN SHEET

Location

Loc Qty

Loc Code

MAT023

126.5

m122033

126.5

therm

1180

m127208

1180

15/05/14

24.2

DQA: _____ Date: _____

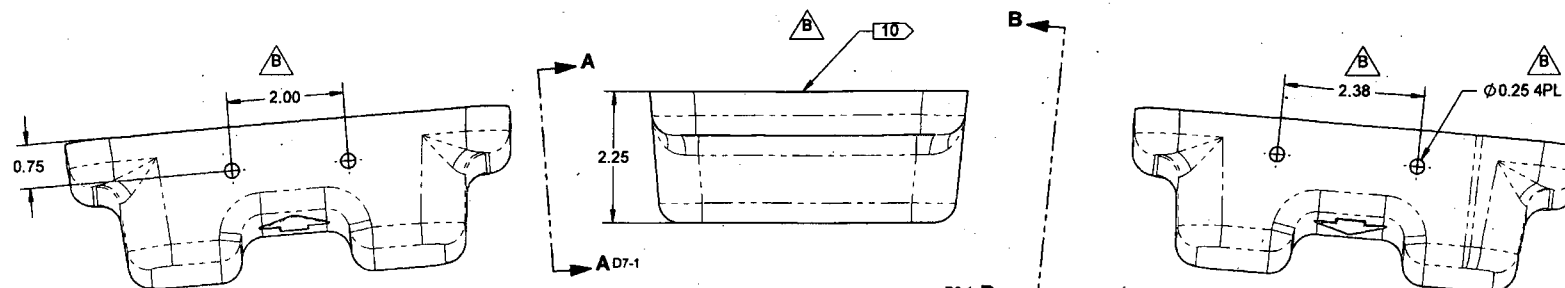


WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

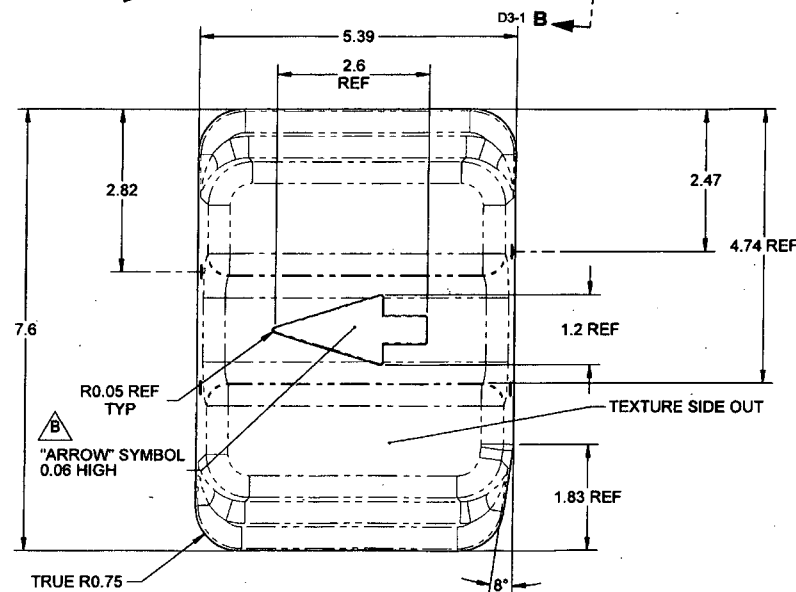
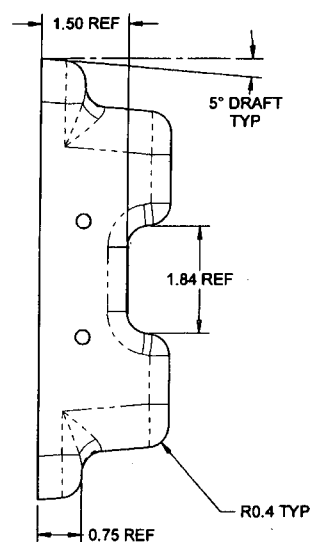
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VIEW A-A D6-1

VIEW B-B D4-1



D4778-1 STUB COVER

NOTES:

- 1) MATERIAL: MLEXS.093-F6006-02 (LEXAN POLYCARBONATE, BLACK, .093")
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4778-1" AND B/N PER DART QSI 044 METHOD 6.4
- 7) WEIGHT: 0.34 lbs
- 8) TOOLING: THERMOFORM PER MOLD DT9887 PER QSI 022. TRIM PER MOLD.
- 9) MINIMUM MATERIAL THICKNESS AFTER FORMING IS 0.040"
- 10) BOTTOM EDGE MAY BE TRIMMED, AS REQUIRED, TO ACCOMMODATE VARIATIONS IN FLOOR SURFACE

B	DIMENSIONAL TOLERANCES RELAXED (ZN D2-1, ZN D3-1, ZN D7-1), ADD TRIM NOTE 10 (ZN D5-1), ADD ARROW (ZN B6-1)	DB	13.04.03
A	NEW RELEASE	DB	13.03.01
REV.	DESCRIPTION	BY	DATE
DESIGN	DB		
DRAWN	DB		
CHECKED	A.P.		
MFG. APPR.	Mc		
APPROVED	Mc		
DE APPR.	Mc		
DATE	13.04.03		
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D4778 TITLE STUB COVER REV. B SHEET 1 OF 1 SCALE NTS COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

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